



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

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Fax 613 632-5246

**RBEA62310**  
**Job Sheet 197488**



Part No: RBEA62310

Job Qty: 8 pcs

Part Name: AS350/355 Engine Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/9/19

Description:

Type: SOLD

Note: DWG RBEA62310 Rev 1A IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Small Fab - 1               | 8 pcs | 8/9/19     |          | 0.00      | 8.00    | Small Fab - 1         |           |          |
|       |                             |       |            |          |           |         | Small Fab - 2         |           | MLL      |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |          |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |          |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |          |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |          |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |          |
| 120   | QC 5                        | 8 pcs | 8/9/19     |          | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |          |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |          |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 40             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 61             |           |          |
|       |                             |       |            |          |           |         | QC 5 - 81             |           |          |
|       |                             |       |            |          |           |         |                       |           |          |
|       |                             |       |            |          |           |         |                       |           |          |
| 130   | Packaging 3-1 - Stock - B4B | 8 pcs | 8/9/19     |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |          |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |          |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |          |
|       |                             |       |            |          |           |         | Packaging 3 - 4 - B4B |           |          |
|       |                             |       |            |          |           |         | Packaging 3 - 5 - B4B |           |          |



Container No: S199151



Part: RBEA62310

Job No: 197488

Serial No/Batch: S199151

Revision: 1A

Inspector:

Exp Date:

Instructions:

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www.dartaerospace.com

Date: 07/19/19

DAS  
81  
9-89

JUL 19 2019

Plex 7/9/19 9:54 AM Dart.lajeunesse.marie

|     |            |       |        |                        |                 |
|-----|------------|-------|--------|------------------------|-----------------|
|     |            |       |        | Packaging 3 - 6 - B4B  | DAS             |
|     |            |       |        | Packaging 3 - 7 - B4B  | 28              |
|     |            |       |        | Packaging 3 - 8 - B4B  | 9-89            |
|     |            |       |        | Packaging 3 - 9 - B4B  |                 |
|     |            |       |        | Packaging 3 - 10 - B4B |                 |
|     |            |       |        | Packaging 3 - 11 - B4B |                 |
|     |            |       |        | Packaging 3 - 12 - B4B |                 |
|     |            |       |        | Packaging 3 - 13 - B4B |                 |
|     |            |       |        | Packaging 3 - 14 - B4B |                 |
|     |            |       |        | Packaging 3 - 15 - B4B |                 |
|     |            |       |        | Packaging 3 - 16 - B4B |                 |
|     |            |       |        | Packaging 3 - 17 - B4B |                 |
|     |            |       |        | Packaging 3 - 18 - B4B |                 |
|     |            |       |        | Packaging 3 - 19 - B4B |                 |
|     |            |       |        | Packaging 3 - 20 - B4B |                 |
|     |            |       |        | Packaging 3 - 21 - B4B |                 |
|     |            |       |        | Packaging 3 - 22 - B4B |                 |
|     |            |       |        | Packaging 3 - 23 - B4B |                 |
|     |            |       |        | Packaging 3 - 24 - B4B |                 |
|     |            |       |        | Packaging 3 - 25 - B4B |                 |
|     |            |       |        | Packaging 3 - 26 - B4B |                 |
|     |            |       |        | Packaging 3 - 27 - B4B |                 |
|     |            |       |        | Packaging 3 - 28 - B4B |                 |
|     |            |       |        | Packaging 3 - 29 - B4B |                 |
|     |            |       |        | Packaging 3 - 30 - B4B |                 |
|     |            |       |        | Packaging 3 - 31 - B4B |                 |
|     |            |       |        | Packaging 3 - 32 - B4B |                 |
|     |            |       |        | Packaging 3 - 33 - B4B |                 |
|     |            |       |        | Packaging 3 - 34 - B4B |                 |
|     |            |       |        | Packaging 3 - 35 - B4B |                 |
|     |            |       |        | Packaging 3 - 36 - B4B |                 |
| 140 | QC 21 - SA | 8 pcs | 8/9/19 | 0.00 0.00              | QC 21 - SA - 21 |
|     |            |       |        |                        | QC 21 - SA - 70 |
|     |            |       |        |                        | QC 21 - SA - 53 |

Part Op 110 - 1-Cut -07 and -015 to fit as per note 1 2-Stick -07 to -01 3-Stick -015 to -09 4-Discard -17 turnbuckle hooks 5-  
 Descriptions: Assemble as per DWG. Sheet 1

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: \_\_\_\_\_)

140 - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item  | Component Name                        | Quantity           | Operation         | Container             |
|--------------|---------------------------------------|--------------------|-------------------|-----------------------|
| 30125T403    | Turn Buckle Body                      | 8 pcs (1 ea)       | 110-Small Fab - 1 | 3x5150659 7x415968    |
| 8997K11      | Cushion w/Adhesive Back 60A durometer | .4400 sf (.055 ea) | 110-Small Fab - 1 | 516389.5              |
| RBEA62310-01 | Top Weldment                          | 8 pcs (1 ea)       | 110-Small Fab - 1 | 64 5189915 4x518992.5 |
| RBEA62310-09 | Bottom Weldment                       | 8 pcs (1 ea)       | 110-Small Fab - 1 | 5177116               |

### Job Allocations

| Operation         | Component Part | Required | Inventory | Allocated |
|-------------------|----------------|----------|-----------|-----------|
| 110-Small Fab - 1 | 30125T403      | 8        | 13        | 0         |
|                   | 8997K11        | 0        | 4         | 0         |
|                   | RBEA62310-01   | 8        | 13        | 0         |
|                   | RBEA62310-09   | 8        | 10        | 0         |

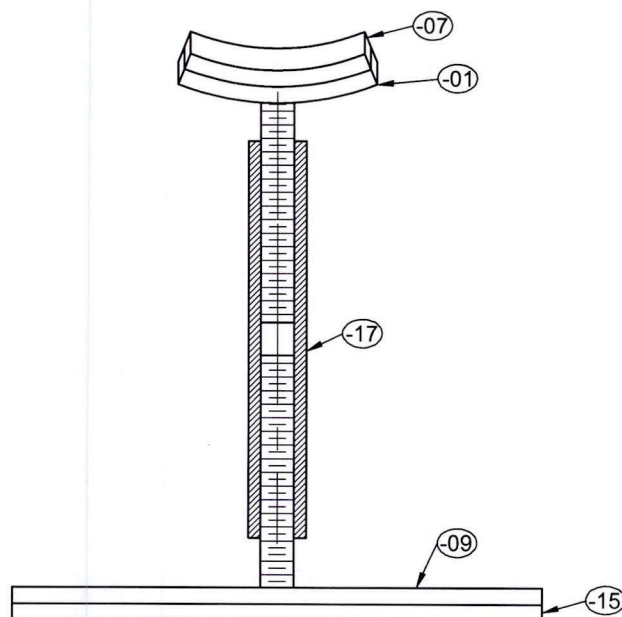
### Part Specifications

Specifications could not be found.



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| REVISIONS |                                                                     |          |         |          |
|-----------|---------------------------------------------------------------------|----------|---------|----------|
| REV       | DESCRIPTION                                                         | DATE     | INITIAL | APPROVED |
| 1         | DELETED -05 10° ANGLE PER S.E. CH'D -03 BOM INFO FROM 1018 PER R.W. | 5/21/12  | RJC     | SE       |
| 1A        | CH'D TOOL NAME WAS ENGINE SUPPORT STRUT IS AS350/355 ENGINE STRUT.  | 11/15/16 | RJC     | RW       |



SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 197488 MLC  
19-07-09

# NOTES

- CUT -07 & -15 CUSHIONS TO FIT.
- DISCARD -17 TURNBUCKLE HOOKS.

| ASSY QTY | ASSY QTY | B/O | PART # | UNIT QTY | DESCRIPTION                | MATERIAL     | B/O INFORMATION OR SPECIFICATIONS                  | Pg. |
|----------|----------|-----|--------|----------|----------------------------|--------------|----------------------------------------------------|-----|
|          |          |     | -01    | 1        | TOP WELDMENT               |              |                                                    | 2   |
|          | 1        |     | -03    |          | TOP PLATE                  | DOM TUBE     | 4 X .120 WALL X 1                                  | 3   |
|          | 1        |     | -05    |          | R/H ALL THREAD             | PLAIN STEEL  | 1/4-20 UNC x 1-13/16 MCMaster-CARR #98750A017      | 4   |
|          | 1        |     | -07    |          | CUSHION WITH ADHESIVE BACK | BLACK RUBBER | 1/8 x 1 x 1-7/16 REF. (MCMaster-CARR #8997K112)    | 1   |
|          |          |     | -09    | 1        | BOTTOM WELDMENT            |              |                                                    | 5   |
| 1        |          |     | -11    |          | BOTTOM PLATE               | 1018         | 1/8 x 1-3/4 x 4                                    | 6   |
| 1        |          |     | -13    |          | L/H ALL THREAD             | PLAIN STEEL  | 1/4-20 UNC x 1-3/4 REF. (MCMaster-CARR #95625A003) | 7   |
| 1        |          |     | -15    |          | CUSHION WITH ADHESIVE BACK | BLACK RUBBER | 1/8 x 1-3/4 x 4 REF. SEE -07                       | 1   |
|          |          | B/O | -17    | 1        | TURN BUCKLE BODY           | ALUMINUM     | 1/4-20 UNC x 3 MCMaster-CARR#30125T403             | 1   |

|                                                                                                                    |                          |
|--------------------------------------------------------------------------------------------------------------------|--------------------------|
| RED BARN MACHINE                                                                                                   |                          |
| TITLE                                                                                                              | AS350/355 ENGINE STRUT   |
| DWG NO.                                                                                                            | RBEA62310                |
| REV                                                                                                                | 1A                       |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES                                                                | DRAWN BY: PERRITT        |
| TOLERANCES ON:                                                                                                     | APPROVED <i>D Weil</i>   |
| DECIMALS .XXX ± .005                                                                                               | HEAT TREAT               |
| .XX ± .01                                                                                                          | FINISH SEE WELDMENTS     |
| .X ± .1                                                                                                            | SPEC                     |
| ANGLES ± 5°                                                                                                        | USED ON MODEL            |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | EUROCOPTER AS350 & AS355 |
| SCALE NTS                                                                                                          | DATE 3-10-10             |
|                                                                                                                    | SHEET 1 of 7             |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                        |              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                        | MRB (QSI042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |